

5/28

(3)

DART AEROSPACE LTD	Work Order:	23622
Description: STA 155 bracket	Part Number:	D2804-1
Dwg: D2803 rev. A	Qty:	19 20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	SA	05.06.21	20
2	METAL	Cut blanks per template DT8534 Material: 6061-T6 bar 1.00" x 0.50" Batch: 417968	SA	05.06.30	19
3	HAAS	Machine as per folio FA103	SA	05.07.03	19
4	QC	Inspect Level 2	SA	05.07.03	19
5	QC	Inspect Level 8	SA	05.07.05	19
6	METAL	Tumble & Deburr	SA	05.07.04	19
7	QC	Inspect Level 5	SA	05.07.05	19
8	FINISHING	Chemical conversion coat per QSI 005	SA	05.07.06	19
9	STORES	Identify and stock	SA	05-08-05	19
10	EXPEDITING	Close W/O Cost / part: 40.35 545 05/08/09 (19) 41.75	SA	05/08/05	19

out of
mat.

PTO

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	

RELEASED

EC 00.11.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-08-05	9	Use 10 for B 23435 and put 9 in stock	ml	05/08/05	9			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-08-05	9							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/08/05

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23622
Description: Bracket		Part Number:	D2804-1
Inspection Dwg: D2804 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010	N/A				Not on Dwg
Ø0.757	+0.005/-0.000	.758	/			
0.608	+0.000/-0.001	.6075	/			
Ø0.191	+0.005/-0.000	.191	/			
1.420	+/-0.001	1.4195	/			
Ø0.507	+0.000/-0.001	.5069	/			
0.250 deep	+/-0.010	.252	/			
Ø0.507	+0.000/-0.001	.5067	/			
Ø0.191	+0.005/-0.000	.191	/			
6.933	+/-0.010	6.934	/			
.7578	+/-0.010	7.577	/			
0.437	+0.000/-0.001	.4365	/			
2.654	+0.000/-0.001	2.5635	/			
12.304	+/-0.010	12.304	/			
0.125	+/-0.010	.125	/			
0.500	+/-0.010	.500	/			
0.125	+/-0.010	.115	/			
0.250	+/-0.010	.252	/			
0.875	+0.000/-0.001	.8741	/			
0.250	+0.000/-0.005	.247	/			

Measured by: <u>BG</u>	Audited by: <u>En</u>	Prototype Approval:	N/A
Date: <u>05.06.30</u>	Date: <u>05/06/30</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	

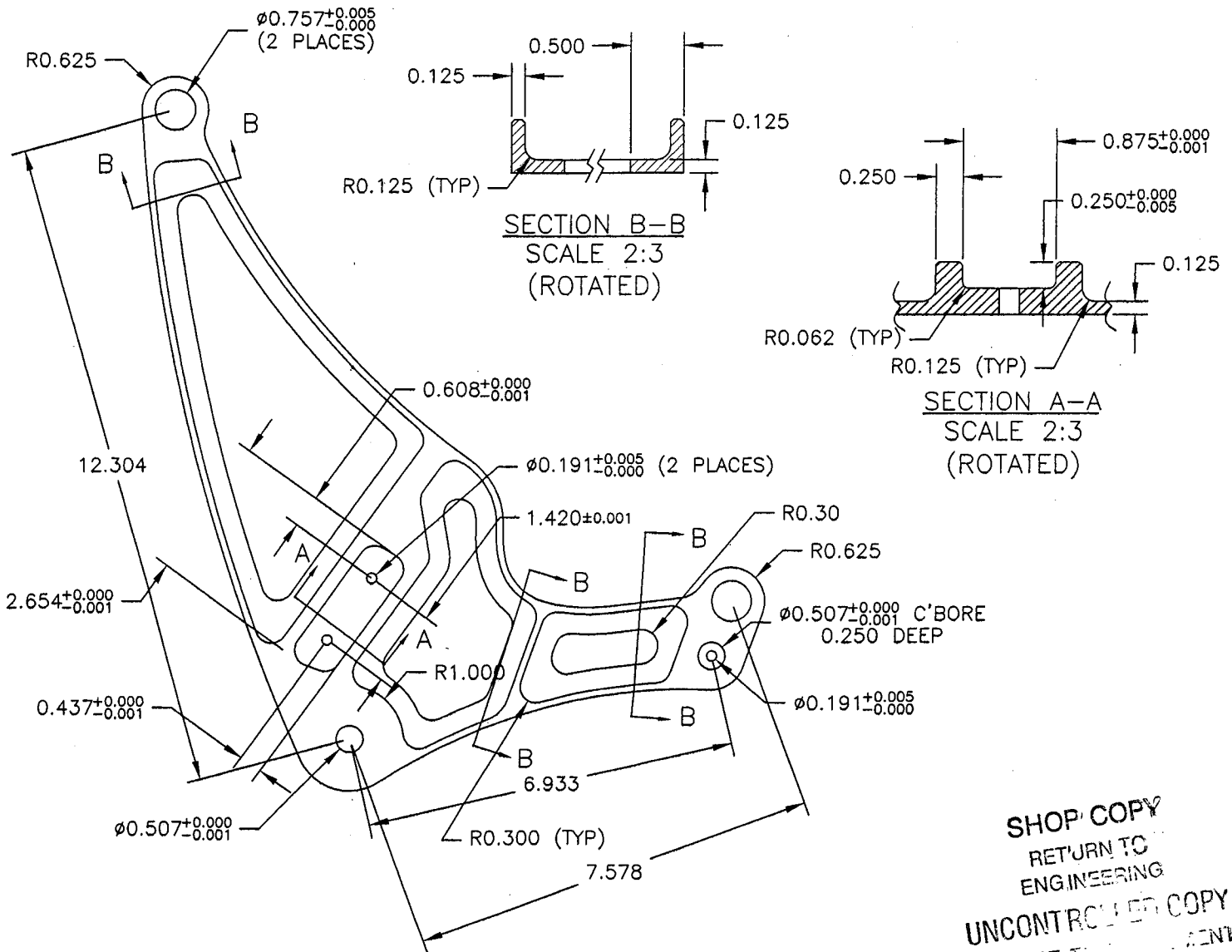
RELEASED
050503



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05-03-11 *[Signature]*



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SUBJECT TO AGENT
WITHOUT NOTICE
WORK ORDER
NO. 23622

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

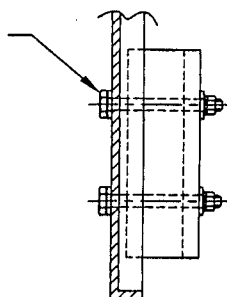
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

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05-03-11
WITHOUT NOTICE

WORK ORDER
NO. 23622

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005

03:23 pm

Work Order No : 0023622
Project Name : D2804-1
Project For : WK528
Work Order Type : Main
Main WO Number :
House Part Number : D2804-1
Description : STA 155 Bracket
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 06-20-05
Est Finish Date : 07-19-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00